

W/JET

8365



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400264-1
Job Sheet 182704



DL-S (MA)
830

8 DAS
21
9-89

015

Part No: RBT400264-1

Job Qty: 8 ea

Part Name: Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/30/18

Job Tracking No:

Due Date: 9/17/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT400264 Rev. 0 IPP Rev. A 18.08.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	9/17/18	9/17/18	0.00	0.00	Start Up Waterjet		DL 18/09/18
110	Waterjet	6 pcs	9/17/18	9/17/18	0.00	0.50	Waterjet 2 OMAX		DL 18/09/18
120	QC	6 pcs	9/17/18	9/17/18	0.00	0.00	QC2 Waterjet-4		DL 18/09/18
130	QC	6 pcs	9/17/18	9/17/18	0.00	0.00	QC8-6		
135	Small Fab	6 pcs	9/17/18	9/17/18	0.00	0.60	Small Fab-6		MLC DAS
140	QC	6 pcs	9/17/18	9/17/18	0.00	0.00	QC5		38
150	Outsource	6 pcs	9/17/18	9/17/18	0.00	0.00	Outsource4		9-89
160	Packaging	8 pcs	9/17/18	9/17/18	0.00	0.00	Packaging2		OCT 15 2018
170	QC	6 pcs	9/17/18	9/17/18	0.00	0.00	QC6		38
180	Packaging	6 pcs	9/17/18	9/17/18	0.00	0.00	Packaging3-1		9-89
190	QC21-SA	6 Ea	9/17/18	9/17/18	0.00	0.00	QC21		OCT 17 2018

Part Op 110 - 1-Cut as per Dwg Dwg Rev: 0 Prog Rev: 0 2-Deburr if necessary (Red Barn folder)

Descriptions: 135 - 1-Ream and countersink holes. 2-Deburr 3-Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

150 - Issue P/O to GROUPE ALTECH; PO 41295 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE 2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required

OCT 10 2018
13
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.3125	6061-T6 .3125 Sheet	1.0320 sf (.172 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.3125	1	45	0

Part Specifications

Specifications could not be found.

Plex 8/30/18 10:40 AM dart.logan.david



Container No: S108338



Part: RBT400264-1

Job No: 182704

Serial No/Batch: S108338

Revision: 0

Inspector:

Exp Date:

Instructions:

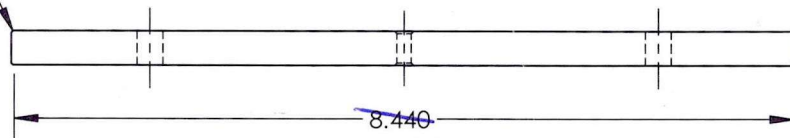
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/06/18

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL

8XR.03



8.440
8.50

ENGRAVE T/N, S/N,
"MADE IN USA"

5.500

4X R.03

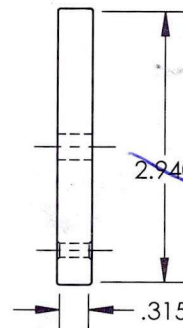
Ø .281
THRU

2X 1.500

2.750

4.250

Ø .156 THRU ALL
Ø .206 X 82° BOTH SIDES



2.940 3.00



RED BARN MACHINE

TITLE

TOOL ASSY

DWG NO.

RBT400264-1

REV

MAT'L 6061

DRAWN BY: CLOUGH

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

APPROVED

.XXX ± .005

FRACTIONS ± 1/32

.XX ± .01

ANGLES ± 5°

.X ± .1

HEAT

TREAT

FINISH

RED ANODIZE

1. BREAK ALL SHARP EDGES .015 x 45°

OR .015R

2. DIMENSIONAL LIMITS APPLY AFTER

PLATING

SPEC MIL-A-8625F, TYPE II, CLASS II

USED ON MODEL

BELL 412

SCALE

1:4

DATE

2/14/2013

SHEET 2 OF 3

(-1)

PLATE

Drawn: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐											
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Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval 																													
Description Work Order Deviation				Disposition																															
Root Cause <table style="width:100%; border: none;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="width:33%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>						Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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		OTHER : _____																																	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041295**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041295
PO Date: 10/10/18
Due Date: 10/17/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182704	RBT400264-1	Plate -Issue P/O to GROUPE ALTECH; PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	10/17/18	8 pcs	0 pcs	8 pcs	\$30.00/pcs	\$240.00
Grand Total:											\$240.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

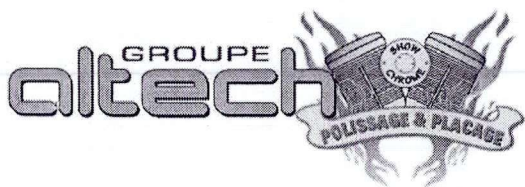
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/15/18 3:47 PM dart.belanger.natasha



Certificat de Conformité / Certificate of Compliance

(013427-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

013427 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
12-Oct-2018		Aman		041295 ✓					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order	
1	RBT400264-1 Rev.	RBT400264-1 ✓ ANODIZE COLOR RED PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	8	8 ✓	0	0	0	DAS 38 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.